Monday, 05/02/2007 11:46:23 AM

User:

Linda Lacelle

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 30558

Estimate Number

: 10383

P.O. Number This Issue

Prsht Rev.

Written By

Comment

: NIA

: 05/02/2007

S.O. No. : NA

: NC

First Issue **Previous Run**

: 30467

: 31/01/2007

Type

: Est:C 02.11.01

Est Rev:B

: SMALL /MED FAB

Now M6061-T6 06-06-23 JLM

Incorporated D3066-1 IPP KJ/RF

Drawing Revision Material **Due Date**

Drawing Name

Part Number

Drawing Number

Project Number

: NIA

: 10/02/2007

: SPACER

: D30661

: N/A

. D3066 REV.B

Each

Additional Product

Checked & Approved By

Job Number:



Seq. #:

Machine Or Operation:

Description: 6061-T6 .080 Sheet

1.0

M6061T6S080

Comment: Qty.:

0.0992 sf(s)/Unit Total:

3.9690 sf(s)Material: 6061-T6 0.080" thick

(M6061T6S.080)

-Batch: <u>4102448</u>

FLOW WATER JET

2.0

WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3066

Dwg Rev:___

Prog Rev:___

2-Deburr if necessary

07/02/10 SAD

07/02/10

3.0

4.0

⊶QC2

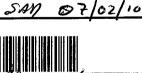
INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



Comment: SECOND CHECK



Page 1

Form: rprocess

Date: Monday, 05/02/2007 11:46:23 AM Linda Lacelle User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: SPACER Job Number: 30558 Part Number: D30661 Job Number: Seq. #: Description: **Machine Or Operation:** HAND FINISHING RESOURCE #1 HAND FINISHING1 5.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 6.0 QC3 Comment: INSPECT CHEMICAL CONVERSION COAT PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 57-17 8.0 Comment: FINAL INSPECTION/W/O RELEASE u oran Job Completion

Wednesday, 1/31/2007 2:19:13 PM Date: Kim Johnston User: **Process Sheet** : SPACER **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer : 30558 Job Number : 10383 **Estimate Number** : D30661 **Part Number** P.O. Number D3066 REV.B : 1/31/2007 S.O. No. : **Drawing Number** This Issue : N/A Project Number Prsht Rev. : NC ; B : SMALL /MED FAB : // **Drawing Revision** Type First Issue : 30467 Material Previous Run : 2/10/2007 Qty: 40 Um: Each **Due Date** Written By Checked & Approved By Incorporated D3066-1 IPP KJ/RF : Est:C Comment Now M6061-T6 06-06-23 JLM Est Rev:B **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: M6061T6S080 6061-T6 .080 Sheet 1.0 (sf(s)/Unit Total: Comment: Qty.: 4 sf(s) Material: 6064-16 0.080" thick (M6061T6S.080) Batch: _ 2.0 WATER JET FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3066 Dwg Rev:___ Prog Rev:___ 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK 5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1

Dart Ae	rospace	Ltd							
W/O:			٧	VORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE		IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	:			·					
Part No	•	PAR #:	Fault Ca	tegory:N	CR: Yes	No DQ	A:	Date:	
					QA: N	I/C Close	d:	_ Date: _	
NCR:		V	VORK OR	DER NON-CONFORMANC	E (NCF	₹)			
D. T.	OTED	Description of NC	Corrective Action Sect		Veri		fication /	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	. Sect	ion C	Chief Eng	QC Inspector
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									-

NOTE: Date & initial all entries

₽ate:

Wednesday, 1/31/2007 2:19:13 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 30558

Part Number: D30661

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

7.0

PACKAGING 1

Location:

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Ae	rospace Li	la constant de la con						
W/O:			WORK ORDER	CHANGES				
DATE	STEP	PROC	CEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	_ Fault Category:	NCR: Y	es No DC	A:	Date: _	
				Q	A: N/C Close	ed:	_ Date: _	
NCR:		W	ORK ORDER NON-CON	IFORMANCE (N	CR)			
DATE	STED	Description of NC	Corrective Actio	n Section B	Verifi	cation	Approval	Approval

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B			A	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30558
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005 -0.000	Ø0.131			Vern	
0.708	+/-0.010	0.713	~	· -	Vern	
0.358	+/0.010	0.356			Verh	
0.350	+/0.010	0.351	<u> </u>		Vern	
2.250 (Pitch)	+/-0.005	2.749	/		Vern	
16.450	+/0.010	16.450	/	-	Vern Vern/H-T	
0.080	1/-0.010				Vern	

Measured by:	5A0	Audited by:	me	Prototype Approval:	N/A
Date: 0つ	102/10	Date:	87/02/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.09.22	New Issue P/O D3065-041	KJ/RF	1
В	06.06.23	Dwg Rev. changed	KJ/JLM 🚓	\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\



DRAWN BY DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA APPROVED DRAWING NO. REV. B CHECKED D3066 SHEET 1 OF 1 DATE TITLE SCALE 06.05.29 **SPACER** 1:3 02.09.11 Α **NEW ISSUE** В 06.05.29 ADD 6061-T6 MATERIAL

> 16.096 16.450

R0.354 (TYP)

- 0.000 RELEASED 0.354 de de ro 2.600 4.850 - 7.100 - 9.350 ϕ 0.128 (#30) (TYP 8 PLACES) · 11.600 13.850

D3066-1 SPACER

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK SHOP COPY (REF DART SPEC M6061T6S.080) RETURN TO

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK

UNCONTROLLED COPY (REF DART SPEC. M5052H32S.080)

2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010 4) PART IS SYMMETRIC ABOUT CENTERLINE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

0.708

0.354 -

6) ALL DIMENSIONS ARE IN INCHES

SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

ENGINEERING

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